

Date: Monday, 02/02/2009 4:02:51 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : D119 HELI UTILITY BASKET
 Job Number : 45429
 Estimate Number : 12452
 P.O. Number :
 This Issue : 02/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D119756041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : IIN PG11-12
 Previous Run : 45428 Drawing Revision : C
 Material :
 Due Date : 01/04/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JLD 09.02.03
 Comment : Est Rev: A New Issue 06-06-14 JLM
 Est Rev. B 06.07.26 dwg revB, picklist EC
 est rev C revC dwg 07.04.09 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 09/03/16



Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 002 5 02/04/21

2.0 45429A BASKET LID ASS'Y (A119)



Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT
 1 x D3515-041 Batch: 45429A SD

3.0 45429B BASKET BASE ASS'Y (A119)



Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT
 1 x D3516-041 Batch: 45429B SD

4.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Spacer
 Batch: 1341928

5.0 D2258220 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Placard
 Batch: 1341928 1332810 9/4/15 SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 45429

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: 1545682

SD

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: 1546589

SD

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 1545389

SD

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 1545662

SD

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: 21139

SD

11.0

D35191

Placard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

placard

1537642

SD

12.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 1109798

9/4/15

SD

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: D119 HELI UTILITY BASKET

Job Number: 45429

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M108928

SD

14.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: M107715

SD

15.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: M108255

SD

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M110625

SD

17.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M110363

SD

18.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M110453

SD

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch: M110523

9/4/15

(K)

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45429

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M110380

SP

21.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch: M110701

SP

22.0	MS20600AD4W3	Cherry Rivets
------	--------------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cherry Rivets

Batch: M107715

SP

23.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M110399

SP

24.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M109282

SP

25.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M109840

SP

26.0	D37571	Blanking Plate
------	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Blanking Plate

batch B38775

9/4/15

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45429

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN311A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M109927

50

28.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M110523

50

29.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch: M110399

9/4/15

(N)

50

30.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D119-756

50

09-04-20

(XV)

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/04/20 (40)

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

33.0

D119756011

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CLAMP KIT

Batch: B45529

9/4/15

(N)

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45429

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0

D26173

Bushing



B46606



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing

35.0

D26175

Spacer



B46607



SP

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spacer

36.0

D351611

Clevis



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
CLEVIS
batch: B45714

37.0

D35171

Strut



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
STRUT
Batch: B46280

38.0

D3518041

Strut Assembly



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
FWD ARM ASSEMBLY
Batch: B46281

39.0

D35201

Spacer



B45568



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SPACER

40.0

AN413A

Bolt



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M110552

9/4/15

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: D119 HELI UTILITY BASKET

Job Number: 45429

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	AN415A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Batch: M110399

SP

42.0	AN420A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M16895

SP

43.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M110363

SP

44.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Batch: M110363

SP

45.0	AN960JD416L	Washer
------	-------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

M110153

SP

46.0	AN960JD516L	Washer
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

M14477

SP

47.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Batch: M109282

9/4/15

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET

Job Number: 45429

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 09/04/22 (10)

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119

Location: _____

PPP Rev: _____

PC 9/4/21 (1)

50.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 (10)

Job Completion



mk
09-04-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart *Heli-Utility-Basket™* which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.

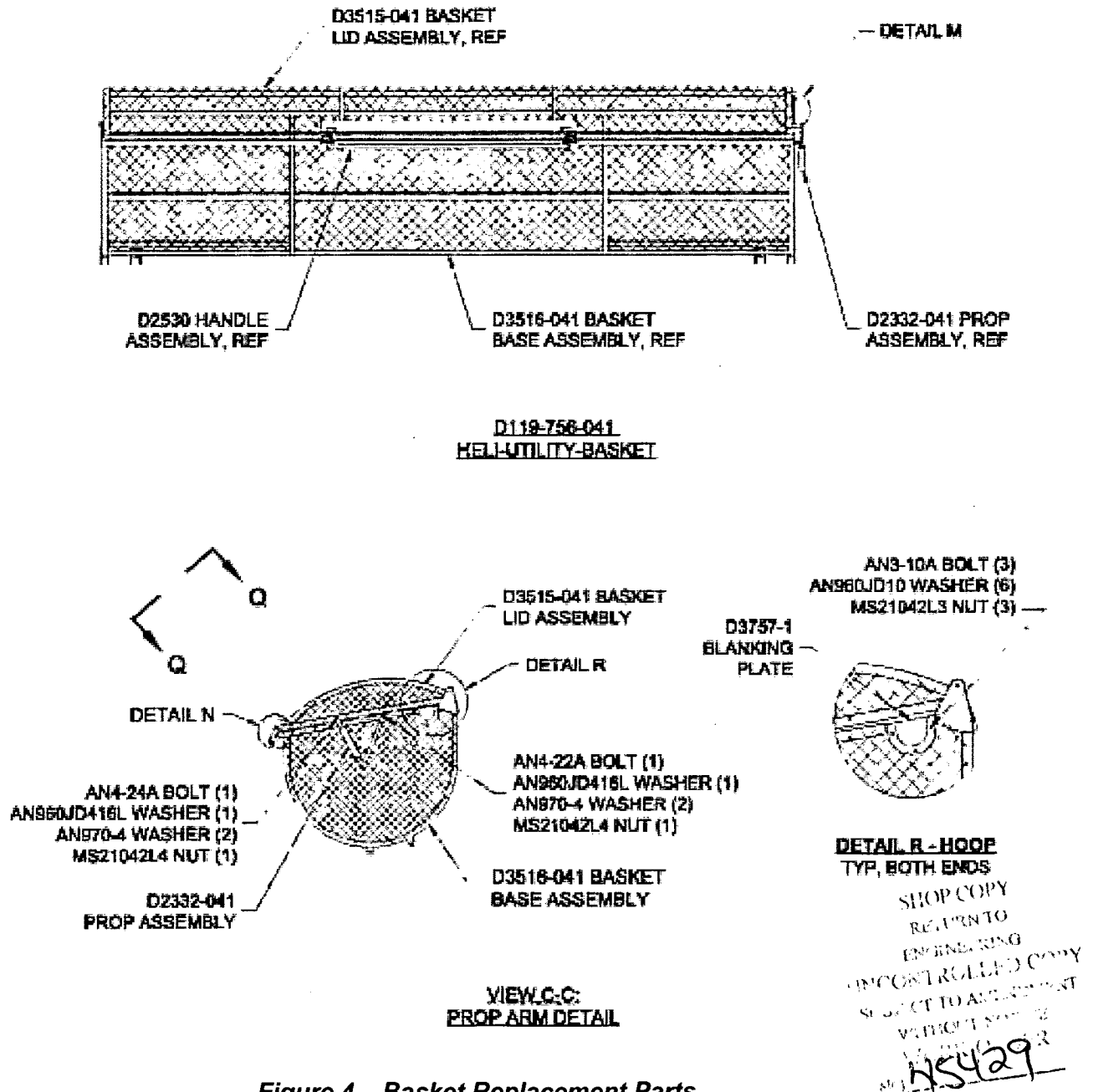


Figure 4 – Basket Replacement Parts
(D119-756-041 Heli-Utility-Basket™)

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Revision: **D**

Date: 08.05.07

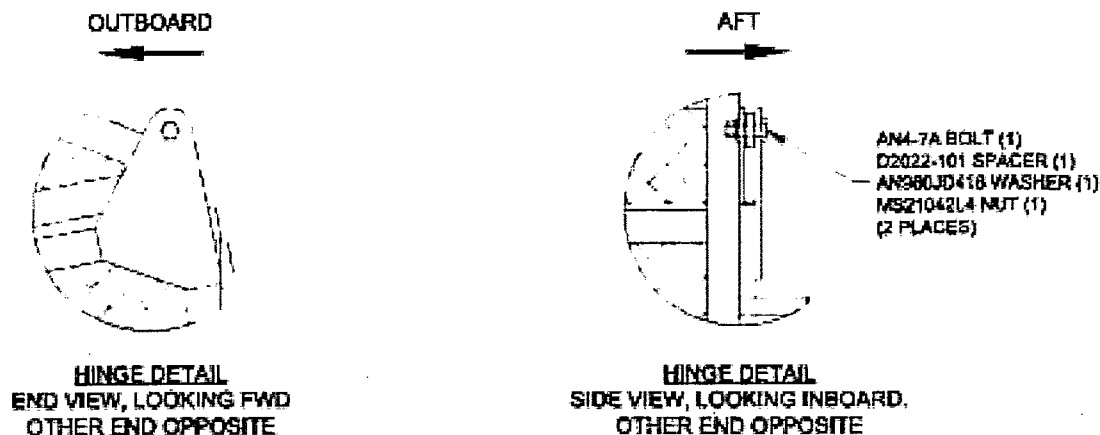
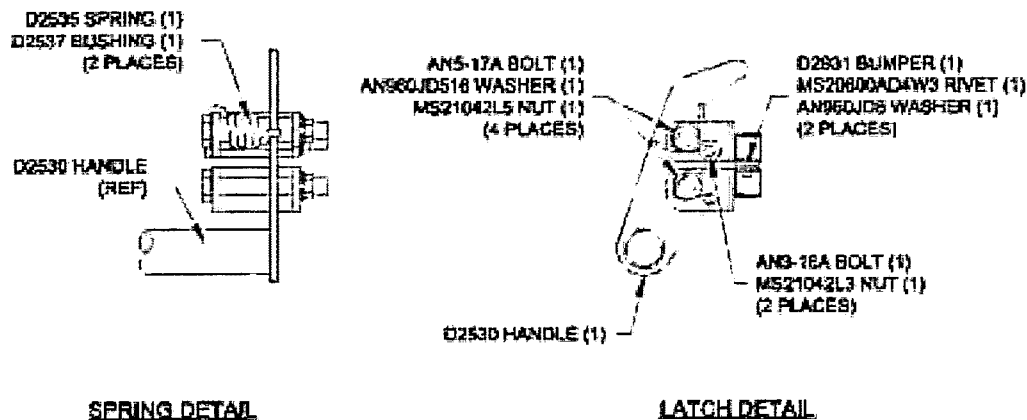
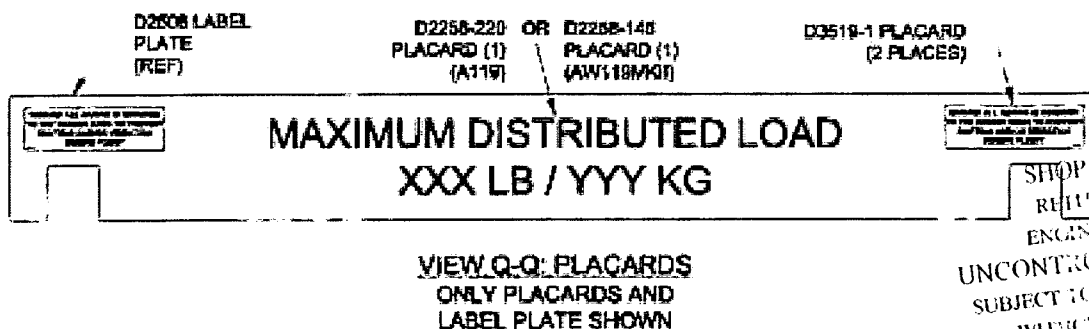
**DETAIL M: HINGE****DETAIL N: HANDLE WELDMENT**

Figure 5 – Basket Replacement Parts & Placards
(D119-756-041 Heli-Utility-Basket™)

5.0 WEIGHT AND BALANCE

There is a negligible weight change associated with the installation of the **D119-756-013 Quick Release Kit**. The following is the weight and balance information for the **D119-756-041 Heli-Utility-Basket™** and the **D119-756-011 Clamp Kit**.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-756-041 Heli-Utility-Basket™ , LH or RH on A119	118.0 lb 53.6 kg	± 46.0 in ± 1.17 m	± 5428.0 lb-in ± 62.7 kg-m	120.0 in 3.05 m	14160 lb-in 163.5 kg-m
D119-756-011 Clamp Kit , LH or RH on A119	0.8 lb 0.36 kg	± 24.5 in ± 0.62 m	± 19.6 lb-in ± 0.22 kg-m	120.0 in 3.05 m	96.0 lb-in 1.1 kg-m
D119-756-041 Heli-Utility-Basket™ , RH only on AW119MKII	118.0 lb 53.6 kg	+ 48.0 in + 1.22 m	+ 5664.0 lb-in + 65.4 kg-m	120.0 in 3.05 m	14160 lb-in 163.5 kg-m
D119-756-011 Clamp Kit , RH only on AW119MKII	0.8 lb 0.36 kg	+ 26.5 in + 0.67 m	+ 21.2 lb-in + 0.24 kg-m	120.0 in 3.05 m	96 lb-in 1.1 kg-m

6.0 POSSIBLE QUICK RELEASE PIN REPLACEMENT

Bolt	Minimum Grip	Replacement Pin P/N
AN4-15A	1.20" (30.5mm)	AVIBANK: BLC4B12S, BLC4TA12S, BLC4R12S, BLC4LA12S MS NUMBER: MS17984C412, MS17985C412, MS17986C412, MS17987C412 REID TOOLS: BLRS-020

NOTE: The qty(2) AN4-15A bolts that secure the D3517-1 Struts mounted on the Basket Base to the D3516-11 Clevises and the qty(2) AN4-15A bolts that secure the top of the Basket Base to the D3518-041 Strut Assemblies may be replaced with stainless steel positive locking quick release pins with a minimum double shear strength of 2400 lbs and 0.25" diameter (10700N and 6.4mm diameter). The **Dart D119-756-013 Quick Release Kit** can be procured from Dart to provide the necessary quick release hardware.

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WITHOUT NOTICE
NO. 45429

7.0 PARTS LIST

Qty -041	Qty -011	Qty -013	Part Number	Description
X			D119-756-041	HELI-UTILITY-BASKET™
1	X		D119-756-011	CLAMP KIT
		X	D119-756-013	QUICK RELEASE KIT
2			D2022-101	* SPACER
1			D2258-220	PLACARD (A119)
1			D2258-146	PLACARD (AW119MKII)
1			D2332-041	* PROP ASSEMBLY
1			D2530	* HANDLE ASSEMBLY
2			D2535	* SPRING
2			D2537	* BUSHING
2	2		D2617-3	BUSHING
4	4		D2617-5	BUSHING
	4		D2732-032	RUBBER CUSHION
2			D2931	* BUMPER
	1		D3041-1	CLAMP (A119)
	1		D3041-3	CLAMP (A119)
	1		D3041-5	CLAMP (A119)
	1		D3041-7	CLAMP (A119)
	1		D3789-1	CLAMP (AW119MKII)
	1		D3789-3	CLAMP (AW119MKII)
	1		D3789-5	CLAMP (AW119MKII)
	1		D3789-7	CLAMP (AW119MKII)
1			D3515-041	* BASKET LID ASSEMBLY
1			D3516-041	* BASKET BASE ASSEMBLY
2			D3516-11	CLEVIS
2			D3517-1	STRUT
2			D3518-041	STRUT ASSEMBLY
2			D3519-1	* PLACARD
2			D3520-1	SPACER
2			D3757-1	* BLANKING PLATE

* indicates that part is pre-assembled on basket for customer

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NO 45429

Qty -041	Qty -011	Qty -013	Part Number	Description
6			AN3-10A	* BOLT
2			AN3-16A	* BOLT
2			AN4-7A	* BOLT
2			AN4-13A	BOLT
6			AN4-15A	BOLT
	2		AN4-17A	BOLT
2	2		AN4-20A	BOLT
1	2		AN4-22A	* BOLT
1	2		AN4-24A	* BOLT
2			AN5-10A	BOLT
4			AN5-17A	* BOLT
2			AN960JD416	* WASHER
40	4		AN960JD416	WASHER
2			AN960JD416L	* WASHER
4			AN960JD416L	WASHER
4			AN960JD516	* WASHER
2			AN960JD516L	WASHER
2			AN960JD8	* WASHER
12			AN960JD10	* WASHER
4			AN970-4	* WASHER
		4	BLRS-020	POSITIVE LOCKING QUICK RELEASE PIN
2			MS20600AD4W3	* RIVET
8			MS21042L3	* NUT (OR MS21042-3)
4			MS21042L4	* NUT (OR MS21042-4)
10	4		MS21042L4	NUT (OR MS21042-4)
4			MS21042L5	* NUT (OR MS21042-5)

* indicates that part is pre-assembled on basket for customer

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